

Date: Thursday, 4/12/2007 7:55:42 AM
 User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FUEL PANEL SHEILD		
Job Number	: 31813					
Estimate Number	: 12810					
P.O. Number	: N/A		Part Number	: D36091		
This Issue	: 4/12/2007	S.O. No. : N/A	Drawing Number	: D3609 UNDER REVIEW		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: U/R		
Previous Run	: 31512		Material	: N/A		
Written By	: E 07-04-12		Due Date	: 4/13/2007 Qty: 1 Um: Each		
Checked & Approved By						
Comment	: Est Rev:A New Issue 07-03-26 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S22GA	304/316 .032 Sheet
		 Comment: Qty.: 0.5256 sf(s)/Unit Total : 0.5256 sf(s) 304/316 .032 Sheet Batch: M102159 <i>m 07 04 12</i> ①
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D3609 Dwg Rev: U/R <i>mnl 07 04 12</i> ② Prog Rev: U/R
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <i>mnl 07 04 12</i> ③ Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK ENGINEERING APPROVAL
		 <i>4 02 04 12</i> ④ Comment: SECOND CHECK <i>AA 07/04/12</i> ⑤
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ <i>FOR ENGINEERING USE ONLY</i> ⑥ <i>00071</i>

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Drawing Name: FUEL PANEL SHEILD

Job Number: 31813

Part Number: D36091

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

10/10/13

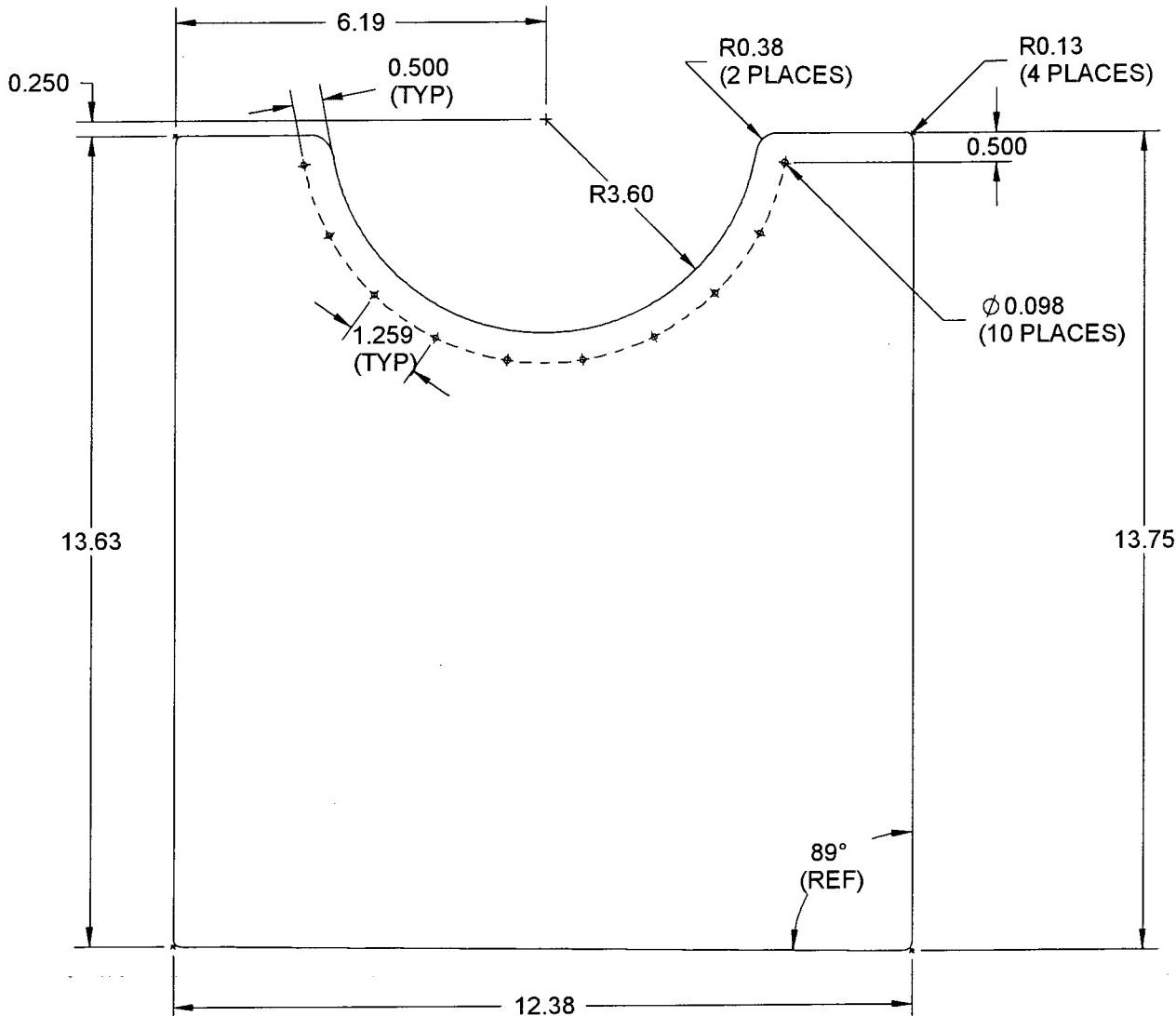
Job Completion



in 10/10/13

PRELIMINARY ISSUE
07.04.11

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3609	REV. A SHEET 1 OF 1
DATE 07.04.11	TITLE FUEL PANEL SHIELD	SCALE 1:3	
REV A	DATE 07.04.11	DESCRIPTION NEW ISSUE	



D3609-1 DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE (0.032 THICK)
PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S24GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3609-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT $\frac{1}{4}$

DART AEROSPACE LTD

Work Order: 31813

Description: Fuel Panel Shield

Part Number: D3609-1

Inspection Dwg: D3609 Rev: U/R

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 12.38	+/- 0.030	12.375	✓		Measuring tape	
B 13.63	+/- 0.030	13.600	✓		Measuring tape	
C 13.75	+/- 0.030	13.75	✓		Measuring tape	
D Ø 0.098	+0.004-0.001	0.098	✓		VERN	
E 0.500	+/- 0.010	0.507	✓		VERN	
F 1.259	+/- 0.00	1.266	✓		VERN	
G 0.500	+/- 0.010	0.508	✓		VERN	
H						
I						
J						
K						
L						
M						
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O						
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Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: *M. M.*
Date: 07/04/12Audited by: *M.*
Date: 07/04/12Prototype Approval: *N/A*
Date: 07/04/12

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	